

Date: Friday, 01/08/2008 3:28:49 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP EXTRUSION		
Job Number	: 40937			Part Number	: D2622120C		
Estimate Number	: 10058			Drawing Number	: D2622 REV C1		
P.O. Number	:			Project Number	: N/A		
This Issue	: 01/08/2008	S.O. No.	:	Drawing Revision	: C1		
Prsh Rev.	: NC			Material	:		
First Issue	: / /	Type	: PURCHASED PARTS	Due Date	: 15/08/2008		
Previous Run	: 40896			Qty:	110 Um: Each		
Written By	:			120			
Checked & Approved By	: <u>NO 08.8.05</u>						
Comment	: Est. A: 02.11.12 New Issue KJ/RF						
Additional Product							
Job Number: 							
Seq. #:	Machine Or Operation:	Description :					
1.0	PG	PURCHASING 					
Comment: PURCHASING Issue P/O: <u>6870</u> <u>C 08/08/05</u> a) Extrude as per Dwg D2622 Rev. C b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation = 8% f) Order at 120" longg) Bon L Canada Inc. tool # 897123 Rev. A h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required							
2.0	D2622120CP	Extrusion 					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 110.0000 Each(s) Extrusion							
3.0	PACKAGING 1	PACKAGING RESOURCE #1 					
Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure material certification is attached <u>→ 08/08/21</u> <u>(120) thru</u> <u>C 08/08/18</u> <u>124</u>							
4.0	QC6	DIMENSIONAL CHECK 					
Comment: DIMENSIONAL CHECK Inspect dimension per Dwg D2622 Check Pull test per Dwg D2622 for compliance page attached Check hardness with Webster tester <u>S 08/08/19 (x124)</u> <u>cont'd</u>							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 3:28:50 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP EXTRUSION

Job Number: 40937

Part Number: D2622120C

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1 B40 937.

Identify and Stock

Location: HALL 003 (36) GA (84)

08/08/21 (22) AM

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/08/22 (22)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

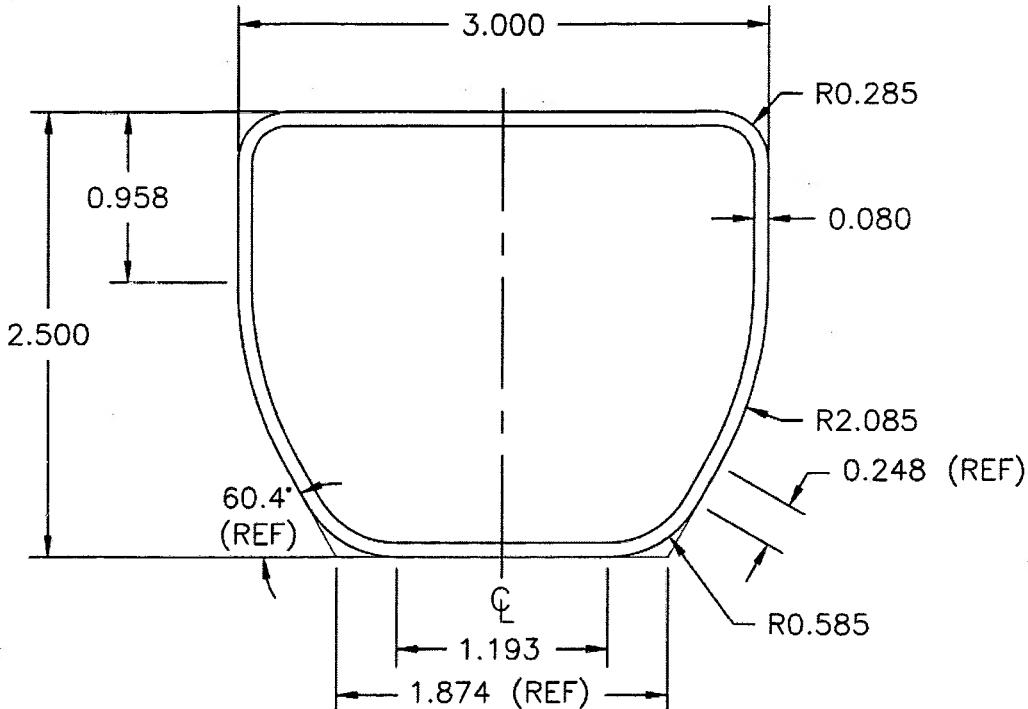
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN KE	DRAWN BY <i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2622	REV. C SHEET 1 OF 1
DATE 02.09.11	TITLE STEP EXTRUSION		SCALE 1:1
A	96.11.29 NEW ISSUE		
B	97.12.12 CHANGE MATERIAL, ADD TOL. QSI		
C	02.09.11 0.080 WAS 0.085; ADD PART & DIE No.		
CI <i># GP</i>	02.10.04 ADD 'REV. A' TO DIE NUMBER.		

RELEASED
02.09.11 *#*D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 REV. A *(c)*
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
 MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 40931



ACCT# 00046024

SHIP TO
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CN

SOLD TO / PURCHASER
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CN

PHONE 613-632-5200

PHONE 613-632-5200

TERMS / FREIGHT
O / P

INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
500 EDWARD AVENUE
RICHMOND HILL ON L4C 4Y9

SHIPPING MANIFEST

MANIFEST DATE	08-15-08
MANIFEST NUMBER	645320
SALES ORDER NUMBER	34987

LOCATION	TRAILER NUMBER	SALESMAN	FIELD SALES REP	CUST. SERVICE REP
RIH	57385	59358	Kutter A 450-435-6551	Burton D 905-427-2227

BILL OF LADING NUMBER
08381709

ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER CUSTOMER PART NUMBER	ALLOY & TEMPER		FINISH DESCRIPTION		THIS SHIPMENT			UNIT	QUANTITY DUE		
					LENGTH		FABRICATION DESCRIPTION		NBR OF PKGS	GROSS POUNDS	NET QUANTITY				
					CUTTING TOLERANCE		SHIPPING TOLERANCE								
01	121	KG M PC	0 0 0	DAA-897123-1 D2622	6061 /T6 120" +3/16 " -0 "		MILL CERTIFICATE OF COMP (+015-015, 0139-0102)		2	541	521 377.95 124	KG M PC	0 0 0		
				LOT/TKT DETAIL: 0			34987010 / 194885 34987010 / 194886		1	213	203 318	49 PC 75 PC			

Transportation/traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifest, and signed and dated below by customers authorized representatives.

No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the Fair Labor Standards Act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE 1

2	541	521 377.95 124	KG M PC
TOTALS			



CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

500 EDWARD AVENUE
RICHMOND HILL, ON L4C 4Y9

Test Date	Cart No.	Sales Order	Page
08/15/08	180248	34987	1
Cust PO	BL No.	For	Date
6870	08381709	34987010	8/15/08

Sold To	Ship To
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-897123-1	120" Mill 6061 T6	D2622
Gross Weight	541 KGS		
Net Wt	521 KG	124 PC	378 M
Specification	AMS-QQ-A-200/8 & ASTM B221-06		

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift	HREW
1	276.6 / 40.1	255.9 / 37.1	9.1	55.0	92	

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.65	.30	.26	.04	.86	.06	.000	.03	.000	.010	.02	.000	.00

S
08/06/08

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

D. VanBakel, QA Manager Signature Aluminum Canada Inc